Work Orde		1019 (*101	1019*					Page 1	
Revision ID:	646.3718 Custom Wash	ier	`	Accept	*N900	<u>04010</u>	∩* s	Setup Sta	1.0	S1* S2*	
Required Date:	5/03/13 5/10/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*	*10 *	Cust Item l Customer:	ID:					
Reference: Approvals:		an: MLZ				ate:	.	Run Sta Sto	" [\]	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan	•	Reject Qty	Reject Number	Insp. Stamp	<u>.</u>
Draw Nbr	Rev	vision Nbr								J.17	-
646.3700	A										•,
110				0.00							
110 Waterjet FLOW CNC Waterj	et	Memo 1-Cut as per Dwg Rev:_ Prog Rev:_	<u> </u>	0.00				O		13:11	0 2
		2-Deburr if	necessary								
120		QC2- Inspect parts off n	nachine FAI/FAIB	0.00						•	
120		Memo		0.00			10			13.1	1.00

Quality Control

NCR:	Yes	/	No

DQA: ____Date: _____

NCR: YE	es / No				WORK ORDER NON-	CONF	UKIV	MANCE / OPI	JAIE	QA Closed:	Date	e:
Work Order	ŕ:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap] _	٨	Skid-tube Aachining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	0				Use-as-is Work Order Update] "		oforming Large Fab	Finishing Composite	Rec/Stoi	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	ial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data												
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	Bending				Bend	Gr	rain			Ovalized		Pressure/Forced
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	Cracks				Broken/Damaged	Ins	specti	on Incomplete		Part Incorre	et [Weld
	Crushed/	'Crimped			Burrs	ins	structi	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Пм.	ainte	nance		Part Moved	_	
<u> </u>	Heat Trea	at		Г	Countersink	Мі	islabel	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Мі	isread			Power Loss/	Surge	Other
T	Ripples in	n Bend	end Drill Holes					Offset				
Torque Waves in Extrusion Drawing						Out of Calibration						
Turning Sequence Finish					Out of Sequence							
	Wave/Twist in Tube Folio						Outside Dimensions					

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Work Orde		01019		*1010			THE RESERVE OF THE PARTY OF THE		Page	
Revision ID:	646.3718 Custom Was	her		Accept	N90004	010 0)* s	Setup Star Stop	1 1	S1* S2*
	5/03/13 5/10/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:				I	.7/
Approvals:	Process Pl	an:	Date:	Tooling:	Date:		F	Run Star	!/	R1 *
	QC:		Date:	SPC (Y/N):	Date:			Stop	*N	R2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	-		and check	Set Up/ Run Hours 0.00 DAS 27 0.00 39-89	Tool ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* Outsource4 Outsource process -	Anodize	Outsource process-Anod Memo Issue P/O:_ HARD ANG	21915	0.00 0.00 AS PER DWG.(SEE NOTE 2)			Ca	X 1311	11/06	(10)

Receive & Inspect for Damage & Mat'l Certs

0.00

150 Packaging

Memo

0.00

Packaging

[=13/4/22 (w)

NCR: Ye	s / No				WORK ORDER NON-C	ONFO	RMANO	CE / UPI	DATE	04.61		
										QA Closed:	Date	9:
Work Order	·•				DISPOSITION				AGAINST D	EPARTMENT	PROCESS	
WOIR OIGEI	•				Rework	1	Skid-tu	ıbe	Crosstube	7	Water Jet	Engineering
Part No).				Scrap		Machin	├ ──₹	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Th	ermoform	~ ⊢	Finishing		e/Packaging	Other
NCR No	o.				Work Order Update		Large !	Fab	Composite	1	Supplier	
												<u></u>
Root					ption of work order update	Initia	1	Act		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief I	ng	Descr	ription	Date	Verification	QC Inspector
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Other	_						İ					
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-	Cracks	or concei	itile to t) ³ -	Broken/Damaged	\rightarrow	dware pection Inco	maloto	⊢	Part Incorred	 -	Temperature/Cure Weld
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	Cuffs	Cimped		-	Contamination	$\boldsymbol{\vdash}$	intenance	ompiete/ e	-	Part Moved	33111g L	
-	Heat Trea	ıt		-	Countersink		labeled		<u> </u>	Positioned V	Vrong	
-	Inspection		Tube	-	Cut Too Short	\vdash	read		 	Power Loss/		Other
<u> </u>	Ripples in	•			Drill Holes	Offs			L			15000
<u> </u> -	Torque W		xtrusion	, -	Drawing	\longrightarrow	of Calibrati	ion		-		7
-	Turning S				Finish	\vdash	of Sequence			-		
<u> </u>	Wave/Tw				Folio		side Dimen				-·	

DQA:

Date:

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Work Ord April-30-13 2:3		1019 		*101	1019*			Page	3
Item ID: Revision ID: Item Name:	646.3718 Custom Wash	er .		Accept	*N90004	101003		Start *NS1* Stop *NS2*	-
Start Date: Required Date: Reference:	5/03/13 5/10/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:				
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:			*NR1* Stop *NR2*	
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours 0.00 27 380	Tool ID To		Accept Reject Qty Qty	ct Reject Insp. Number Stamp	
170 SprayPaint Spray Painting			√ MIL-P-23377J TYPE1 (. 4860-50 PRIMER BAT(0.00 0.00 CLASS N AS PER DWG	(SEE NOTE 2) Prime & A	tG	X1	3/11/04 (10	
180 *1 R * QC Quality Control		QC14- Inspect Spray Pa	int	0.00	DAS 27 9-89		10		-

											DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UPDAT	Έ			-	
											QA Closed:	Da	ite:	
Work Orde	or.					DISPOSITION			A	AGAINST DE	PARTMENT	/PROCESS		
Work Orac	٠					Rework	1	İ	Skid-tube Cr	rosstube		Water Jet	П	Engineering
Part N	Vo.					Scrap	1		—	mall Fab	Pro	d. Eng. Coor.	\vdash	Quality
	•					Use-as-is	1			Finishing		re/Packaging	\vdash	Other
NCR 1	No.					Work Order Update	1	1	~ }	mposite	,	Supplier	_	H
	•						•		·					
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descriptio	n	Date	Verificatio	n	QC Inspector
Doc/Data					ļ									
Equip/Tooling	Ш													
Operator			ļ							:			-	
Material														
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Other														
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Supplier	Ш		Į.											
Training	$ldsymbol{ld}}}}}}$											i		
Unapproved							<u>L</u>							
						F,	AUI	LT CATE	GORY					
Landi	ng (1				General	_	-			ı		_	•
	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Bending				Bend		Grain			Ovalized		Ш	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	· -	—	Over/Under			Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged		→ '	on incomplete		Part Incorred		-	Weld
	<u></u>	Crushed/	Crimped		ļ	Burrs		4	ions Incomplete/Unclea	ar	Part Lost/Mi	ssing		Wrong Stock Pulled
	I	Cuffs			[Contamination	1	Mainte	enance	{	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Work Ord April-30-13 2:		01019		*101				Page 4			
Item ID: Revision ID: Item Name:	646.3718 Custom Was	her		Accept	*N900	040	100)* 5	Setup Star Stop	1.71	S1*
Start Date: Required Date Reference:	5/03/13 : 5/10/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:				10	
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		I	Run Star Stoj	17	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			510	′ *N	R2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Stoo	ck Location: 5752 4	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Packaging Packaging		Memo	Y AS PER APICAL MPP-I	0.00	JE D# AND			_[43/4	25	F 0

QC21- Final Inspection - Work Order Release

0.00

200

Quality Control

Memo

REV***

0.00

Am 13/11/25

WH 25

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	·		
										-	QA Closed:	Date	:
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	•					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	•					Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	4	re/Packaging Supplier	Other
Root			<u> </u>		•	otion of work order update	1	Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training													
Unapproved	<u> </u>							LT CATE	CORY				
Landi	ina (General	AUI	LICATE	GORT				
Landi		Bending	at Canca	ntric to (Bend BOM/Route	F	Grain Hardwa	r 0	F	Ovalized Over/Under	tolorance	Pressure/Forced Temperature/Cure
:	Centre Not Concentric to O/S Cracks),, -	Broken/Damaged		Inspecti	on incomplete		Part Incorred	ct	Weld
	<u> </u>	Crushed/	Crimped			Burrs	<u> </u>	-	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination	Maintenance			Part Moved			
	-	Heat Trea		Tuba	<u> </u>	Countersink				Positioned Wrong Power Loss/Surge		704	
	\vdash	Inspectio		iube	-	Cut Too Short	\vdash	Misread	1	L_	Jrower Loss/	Surge	Other
	1	Ripples in	n Bend		- 1	Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-30-13 2:38:24 PM

Work Order ID:

101019

Parent Item:

646.3718

Parent Item Name:

Custom Washer

Start Date: 5/03/13

Required Date: 5/10/13

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

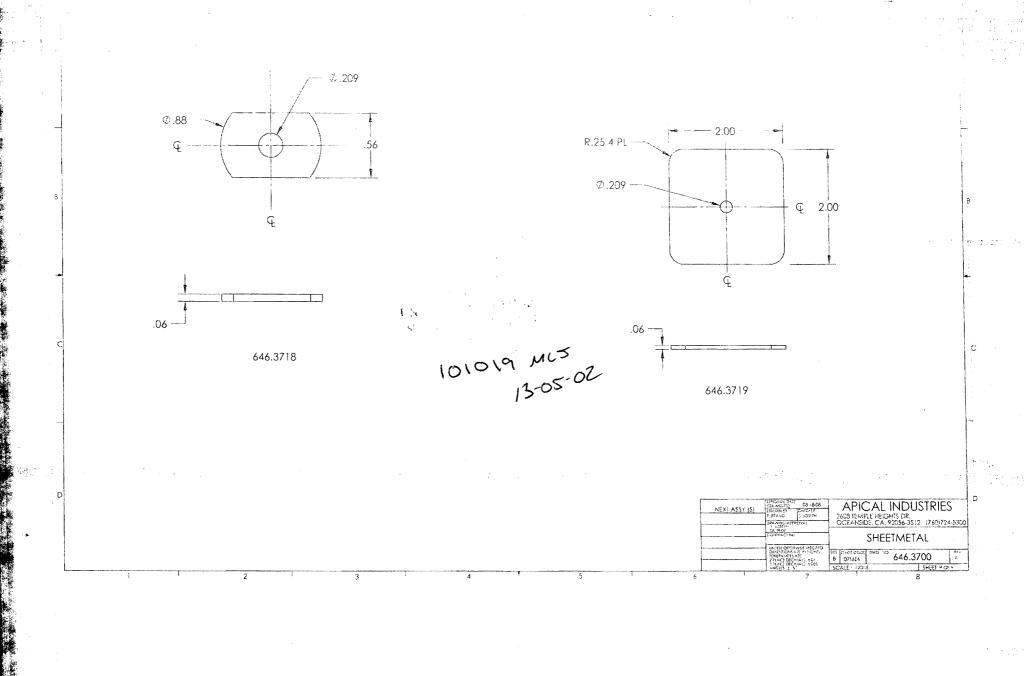
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			110	sf	503.1125	0.0034	0.0178945	A	-13	11.0
e se 💉				Location		Loc Qty	<u>Lo</u>	c Code					
, á				MAT021		503.1125							
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NCR:	Yes	1	No
NCK.	162	1	INO

Date:

DQA:

NCR: Y	es 	/ No					WORK ORDER NON-C	.Or	WFORIN	MANCE / UPL	JAIE		QA Closed:	Dat	te:	
Vork Orde	ŕ:						DISPOSITION				AGAIN	ST DE	PARTMENT	PROCESS		
Part N	-						Rework Scrap		ı	Skid-tube Machining	Crosstu Small F	ab		Water Jet d. Eng. Coor.		Engineering Quality
NCR N	lo.						Use-as-is Work Order Update			noforming Large Fab	Finishi Compos		Rec/Stor	e/Packaging Supplier		Other
Root					Desc	ript	tion of work order update	ı	Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	<u>1</u>	QC Inspector
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napproved																
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Landir		Bending Centre No Cracks Crushed/G		ntric to (o/s		General Bend BOM/Route Broken/Damaged Burrs Contamination		• '	on Incomplete ions Incomplete/L	Jnclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	:t		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Trea		Tube			Countersink Cut Too Short	F	Mislabe Misread				Positioned V Power Loss/	· · ·		Other
		Ripples in			T		Drill Holes		Offset			-				
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration						
		Turning S	equence				Finish		Out of S	Sequence						
Wave/Twist in Tube Folio Outside Dimensions																



DART AEROSPACE LTD	Work Order:	101019
Description: (USTON WOTH	Part Number:	D646.378
Inspection Dwg: 646, 3700 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension		Tolerance		Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø	.209	+6.005	1-,001	.209"	<i>~</i>		V	JKM-01
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		+1-		.059	-		<u> </u>	
								
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		<u> </u>	1		DAS			

Measured by:

Date: 13'// O Date: Da

Rev	Date	Change Revised by Approve	d
E	10.04.14	Added preliminary approval KJ	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62753

Date: 22-Nov-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via				
		1 100				
Quantity	Description					
1	Part: ASST	Re	ev:			
lot						
	10 PCS 646.3312 (12.05)					
	12 PCS 646.3010 (10.25) 6 PCS 646.3310 (18.10)					
	2 PCS 645.3110 (10.65)					
	4 PCS 646.3810 (6.55)					
	32 PCS 646.3715 (6.70) 38 PCS 646.3718 (3.95)	-/0				
	6 PCS 646.9812 (22.80)	<u> </u>				
	LIARRANICRIZE DI ACK					
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2					
	WILL-A-0020 FIFE III OLAGO 2					
	PRIME MIL-P-23377J TYPE I CLAS					
	PRICE IS PER PIECE					
	Job: 20130724	PO: 21915	Line:			
	A.T.G. Industries certifies that all items in					
	with all requirements, specifications and drawings referenced in the purchase order.					
	ISO 9001 : 2008 REGISTERED					
	, ATG SALES-2010 TERMS APPLY					
	DATE: 22/11/13					
	CERTIFIED SIGNATURE :					
	RECEIVER SIGNATURE :	<u> </u>				
	·					